

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021677**Date Inspected:** 21-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

Bay 10

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 10 ZPMC was in process of SMAW welding on bike path subassembly BK010-001. ZPMC QC inspector Li Peng Fei was present at this time of this observation and informed this QA inspector of the work that is in process and identified Guo Yan Fei as the CWI. It was stated that ZPMC had 2 welders performing MT repairs and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

(WR16925)

Weld- BK010-001, (BKX55A, BKX55C, BKX33W, BKX32X. BKX32S)

WPS-345-SMAW-2G(2F)-Repair

Welder-052930, 057528

2F/SMAW

This QA inspector observed ZPMC in process of SMAW welding on bike path assembly BK004A2-031. ZPMC QC inspector Xu Zhi Lai was present at this time of this observation and informed this QA inspector of the work that is in process and identified Zhang Huang as the CWI. It was stated that ZPMC had 1 welder performing weld repair and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

inspector verified this information for the following location;

(WR16923)

Weld- BK004A2-031-024

WPS-345-SMAW-4G(4F)-Repair

Welder- 057258

4G/CJP/SMAW

This QA inspector observed ZPMC in process of FCAW (ESAB) welding on bike path assembly BK009A4-001. ZPMC QC inspector Xu Zhi Lai was present at this time of this observation and informed this QA inspector of the work that is in process and identified Zhang Huang as the CWI. It was stated that ZPMC had 1 welder performing welding and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- BK009A4-001-019

WPS-B-T-2132-ESAB

Welder- 052075

2F/FCAW

This QA inspector observed ZPMC personnel performing Heat Straightening (HSR1 B 10101) on traveler rail TR3005-001 ~ 024. ZPMC CWI inspector Xu Zhi Lai was present at this time of this observation and informed this QA inspector of the work that is in process.

Trial Assembly

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Trial Assembly ZPMC was in process of welding on 12BE. ZPMC QC inspector Zhou Peng was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 3 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

12BE

Weld- SEG3001AG-222

WPS-B-P-2114-FCM-1

Welder-052493

4F/SMAW

12BE

Weld- SEG3001AG-171

WPS-B-P-2212-B-U2-FCM-1

Welder-040378

2G/SMAW/CJP

12BE

Weld- SEG3001AG-221

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

WPS-B-P-2114-FCM-1

Welder-044504

4F//SMAW

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

“As noted within the contents of this report.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler,Mike	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
